

Split
-2
Work Order ID 67842

Thursday, March 31, 2011 3:47:45 PM



Page 1

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Item Name: Seat Frame Assembly

Stop



Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11-03-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100

Weld per dwg A/R 4130 rod Batch: M100075 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig
DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

Q 11425 (X1)

1 8 8 E1/04/27

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Page 2

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Start Date: 4/1/2011 Start Qty: 1.00



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Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u/04/27

(+)

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

MU5128

Memo

0.00

Powder Coating

Install paint screws on fitting ends

START TIME: 12:00

OVEN TEMPERATURE: 320°

FINISH TIME: 12:30

1 - 1/4 u-4-27

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 - 1/4 u/04/23

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Revision ID:
Item Name: Seat Frame Assembly

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Setup Start



Stop



Start Date: 4/1/2011 Start Qty: 1.00
Required Date: 4/7/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location GA

0.00



Packaging

Memo

w/o 68629

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 *[Signature]*
ME
11-04-27

Picklist Print

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Page 1

Work Order ID: 67842

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly



Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.049

Purchased

No

100

f

85.2300

4.3

4.526316



4130 RD Tube .750 x.049W

Location

Loc Qty

Loc Code

MAT033

85.23

10433

10.73

110740

74.5

4.5' x 4.66'

M4130NT0.500W.049

Purchased

No

100

f

81.8400

4.3

4.526316



4130 RD Tube .500 x.049W

Location

Loc Qty

Loc Code

MAT032

81.84

106651

7.09

110740

74.75

7.09

M4130NT1.000W.120

Purchased

No

100

f

1.2200

1.5

1.578947



4130 RD Tube 1.00 x.120wall

Location

Loc Qty

Loc Code

MAT033

1.22

113665

1.22

m117372.1108'

D3016-17

Manufactured

No

100

Each

6.0000

2

2



Gusset

Location

Loc Qty

Loc Code

WA019

6

64618

6

2

EL 11-4-20

EL 11-4-20

EL 11-4-20

Picklist Print

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Page 2

Work Order ID: 67842

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly



Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13



Bracket

Manufactured No

100

Each

14 0000

2

2



EL 11-4-25

Location

Loc Qty

Loc Code

WA019

14

44778

14

2

D3016-15



Gusset

Manufactured No

100

Each

5 0000

2

2



EL 11-4-25

Location

Loc Qty

Loc Code

WA019

5

43413

5

2

D3020-1



Fitting

Manufactured No

100

Each

33 0000

4

4



EL 11-4-25

Location

Loc Qty

Loc Code

WA

33

36713

33

4

Thursday, March 31, 2011 3:47:55 PM

Shop Packet Print

Page 2



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RECEIVED
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67842*
2/11-03-31

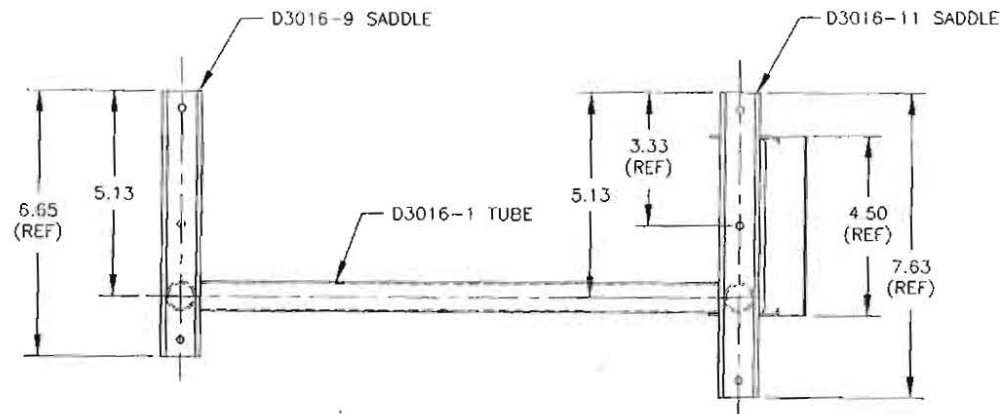
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01.05.30 *#*

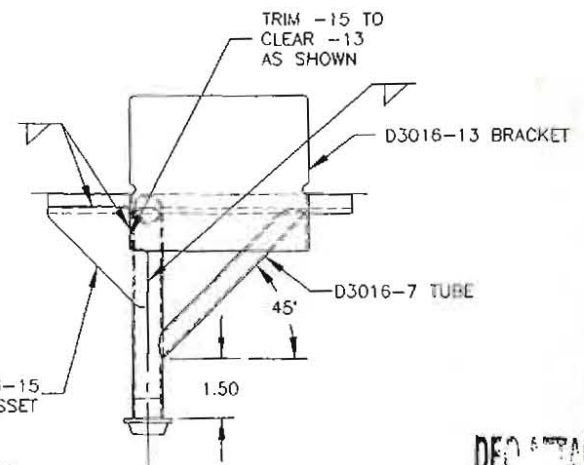
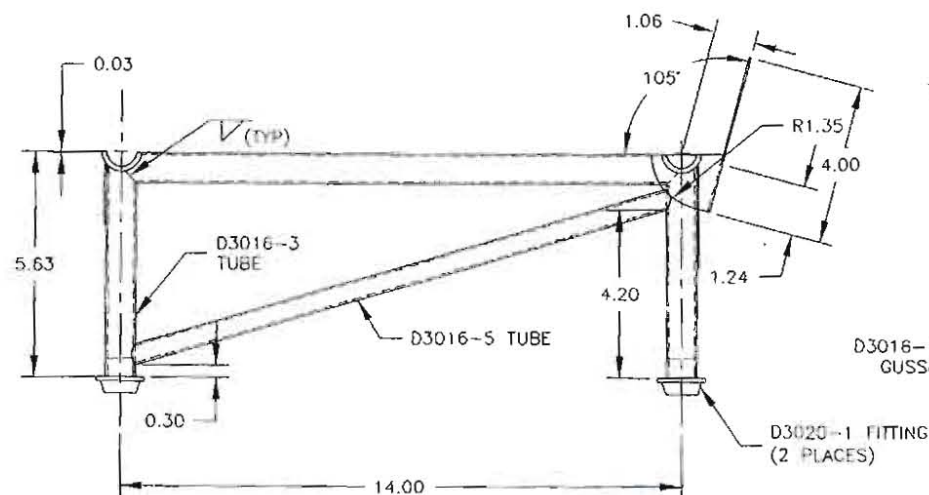
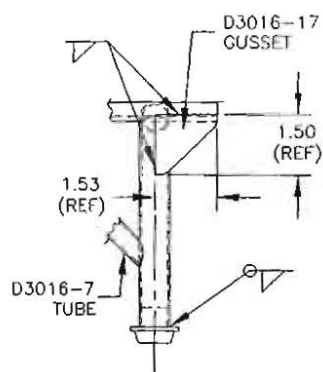
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D3016-041 SEAT FRAME ASSEMBLY



u10 67842



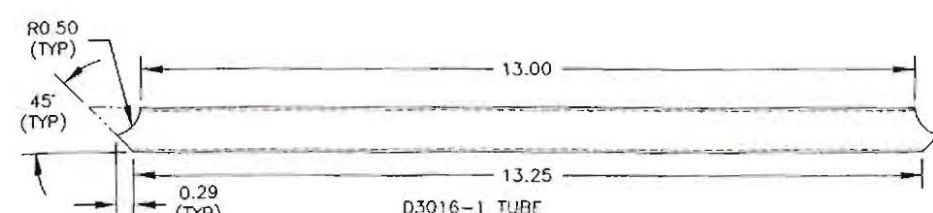
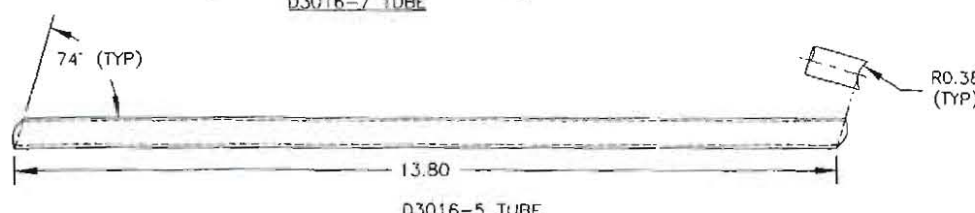
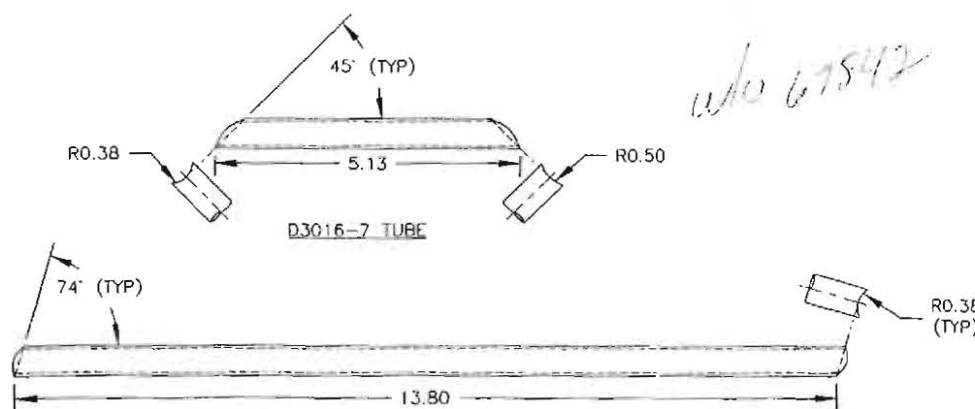
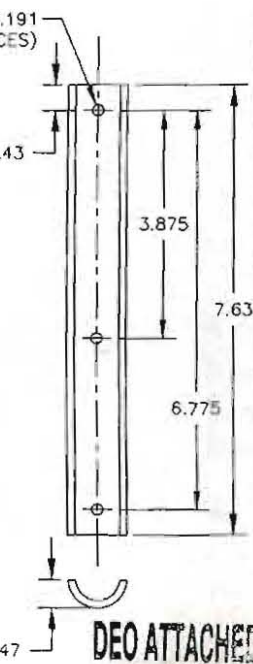
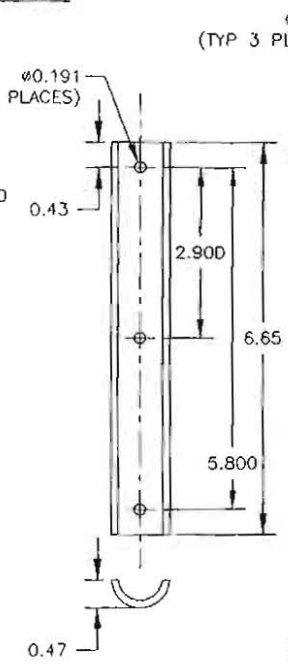
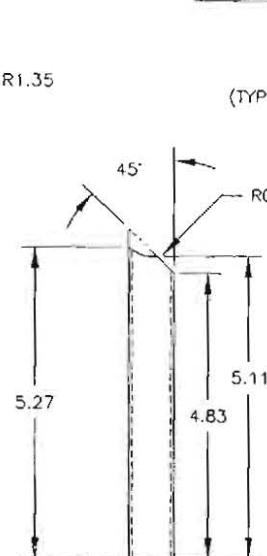
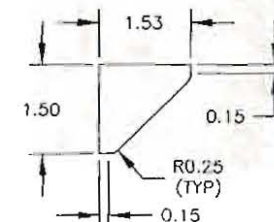
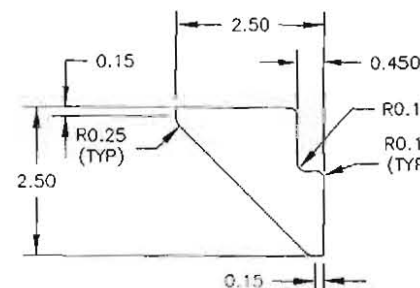
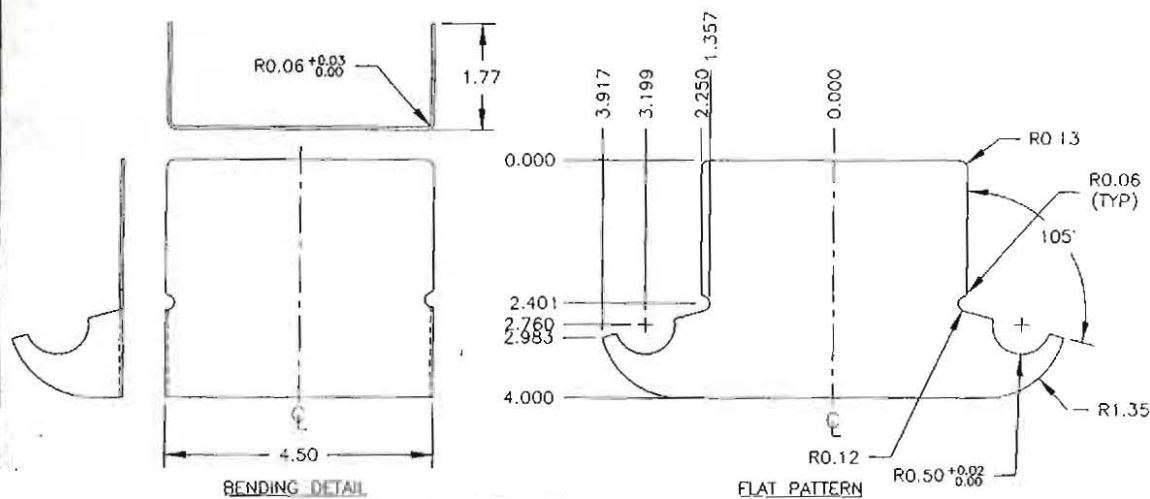
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01.05.30

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DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. THAMESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. 03016	REV. A SHEET 2 OF 3
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE 1:3	



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		DATE		DRAWING NO.	SHEET 3 OF 3
		01.05.18		D3016	SCALE
				SEAT FRAME ASSEMBLY	1:2

DEO ATTACHED
RELEASED
9.05.30

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>R</i>	APPROVED <i>W</i>	DE APPR. <i>W</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

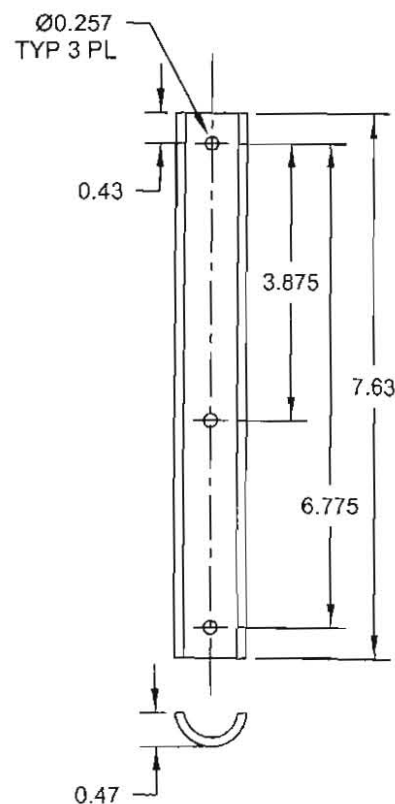
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

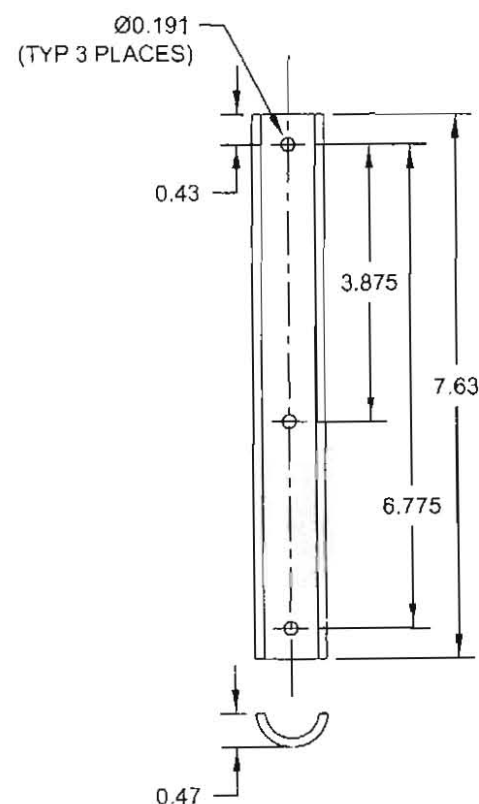
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE